



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SWA6A-100
Job Sheet 190836



Part No: SWA6A-100

Job Qty: 16 pcs

Part Name: Lower End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/15/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/18/19

Description:

Type: SOLD

Note: DWG SWA6A-100 Rev7 IPP Rev A 17.11.15 New issue

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	16 pcs	3/18/19	3/18/19	0.00	1.60	Bandsaw - 1	
110	NLX 2500SY - B4B	16 pcs	3/18/19	3/18/19	0.00	16.00	NLX 2500SY - 1 - B4B	
120	QC 2	16 pcs	3/18/19	3/18/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Container No: S167062



Part: SWA6A - 100

Job No: 190836

Serial No/Batch: S167062

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/28/19

Plex 2/15/19 1:15 PM Dart.lajeunesse.marie

Plex 2/15/19 1:15 PM Dart.lajeunesse.marie

150 QC 21 - SA	16 pcs	3/18/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	APR 11 2019 70
					QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blanks to 5.90".

Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per folio FB703 FOLIO REV: AA DWG REV: 7

2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.500	17-4 SS H1150 Round Bar 2.500"	7.8400 ft (.49 ea)	100-Bandsaw - 1	5166336

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R2.500	8	5	0

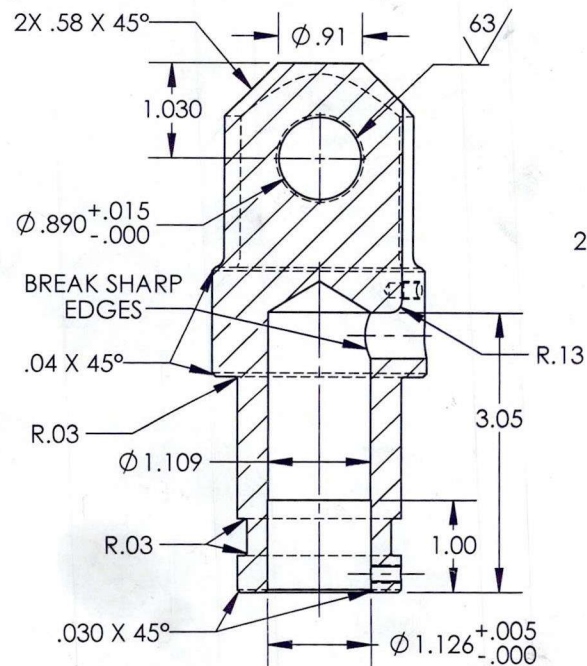
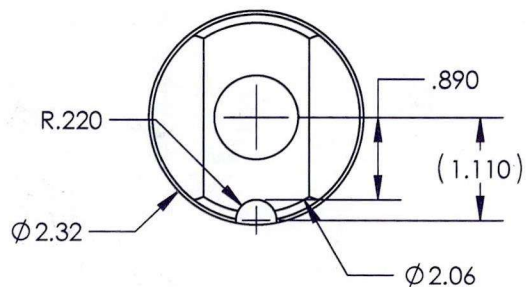
Part Specifications
Specifications could not be found.

Plex 2/15/19 1:15 PM Dart.lajeunesse.marie

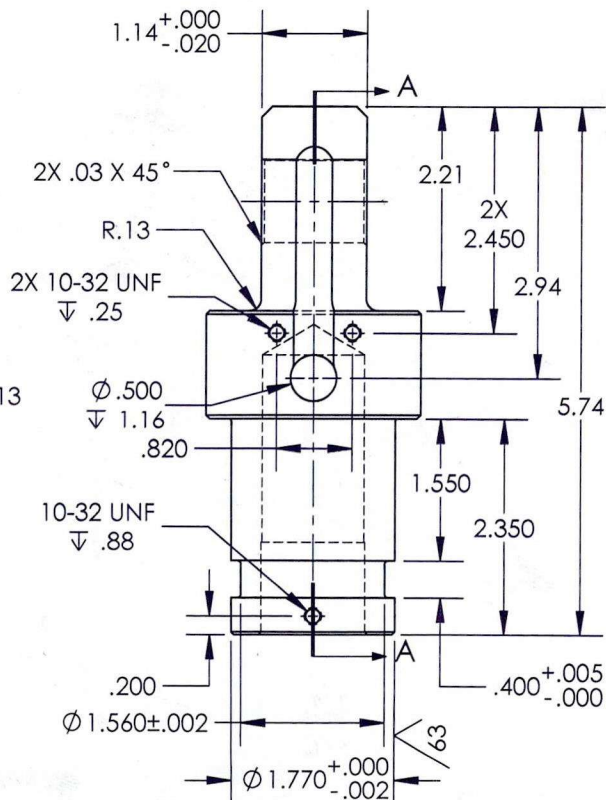
95 Pounds

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
6		AS DRAWN BY CANAM.	11/15/2012	JAG
7	15-0088	CH'D DIMENSION OF TOP FLANGE WAS 1.14 IS 1.14 +.000 -.020.	4/16/2015	RJC



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190836415
1902-15

DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA6A-100	REV 7
MAT'L SS 17-4, H1075, H1150	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH SPEC USED ON MODEL
SCALE 1:2	DATE 2/1/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-100	1	LOWER END	SS 17-4, H1075, H1150	Ø2-1/2 X 5-7/8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 190836
Description: Lower End		Part Number:
Inspection Dwg: SWA6A-100	Rev: 7	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.91	±.01	.910			Vern LPI0	
.58 x 45°	±.01 x .5°	.575 x 45				
1.030	±.005	1.0325				
Ø.890	+0.015 / -0.000	.8925				
.04 x 45°	±.010 x .5°	.04 x 45°				
R.03	±.01	.032			Rad gauge	
Ø1.109	±.005	1.107			Vern LPI0	
R.03	±.01	.032			Rad gauge	
.030 x 45°	±.005 x .5°	.030 x 45°			Vern LPI0	
Ø1.126	+0.005 / -0.000	1.1285				
3.05	±.01	3.051			H-gauge	
R.13	±.01	.125			Rad gauge	
1.00	±.01	1.003			Vern LPI0	
R.220	±.005	.218				
Ø2.32	±.01	2.318				
Ø2.06	±.01	2.058				
.890	±.005	.890				
1.14	+0.000 / -0.020	1.125				
.03 x 45°	±.01 x .5°	.03 x 45°				
R.13	±.01	.125			Rad gauge	
10-32 UNF	GO - NO GO	GO			GO/NOGO	
Ø.500	±.005	.500			Vern LPI0	
.820	±.005	.822				
10-32 UNF	GO - NO GO	GO			NO - NOGO	
.200	±.005	.199			Vern LPI0	
Ø1.560	±.002	1.5605			Mic LPI02	
Ø1.770	+0.000 / -0.002	1.7695				
.400	+0.005 / -0.000	.403			Vern LPI0	
2.350	±.005	2.349				

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 19-04-03	Date: 19/04/09	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

